

Date: Wednesday, 18/06/2008 11:20:41 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services			<b>Drawing Name</b>	: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE		
<b>Job Number</b>	: 39914			<b>Part Number</b>	: D29392		
<b>Estimate Number</b>	: 10937			<b>Drawing Number</b>	: D2939 REV C		
<b>P.O. Number</b>	:			<b>Project Number</b>	: N/A		
<b>This Issue</b>	: 18/06/2008 <b>S.O. No.</b> :			<b>Drawing Revision</b>	: C		
<b>Prsh Rev.</b>	: NC			<b>Material</b>	:		
<b>First Issue</b>	: / / <b>Type</b> : MACHINED PARTS			<b>Due Date</b>	: 05/07/2008 <b>Qty:</b> 8 <b>Um:</b> Each		
<b>Previous Run</b>	: 36144						
<b>Written By</b>	:						
<b>Checked &amp; Approved By</b>	: <u>JUL 08/08/18</u>						
<b>Comment</b>	: Est: B 00.06.26 New DWG rev (mpp 2069) EC Est Rev:C As per Rev C 07-03-19 JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101001	Saddle Billet	
		<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Issue material from stock: 7075-T7351 (QQ-A-250/12) Cut Size 2.0" x 6.25" X 6.00" Grain Along 6.00" Length Batch No: <u>634872</u>	<u>88 08/06/09</u>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		<b>Comment:</b> HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 5-Deburr	(8) <u>DIP 08/06/24</u>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		<b>Comment:</b> CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	(8) <u>DIP 08/07/01</u>
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		<b>Comment:</b> INSPECT ALL DIM TO DIM SHEET	(8) <u>DIP 08/07/01</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 18/06/2008 11:20:41 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 39914

Part Number: D29392

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

mf 08/07/02

(8)

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(8X)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

mf 08/07/02

7.0 POWDER COATING POWDER COATING



m107925

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 2:30

OVEN TEMPERATURE: 320

FINISH TIME: 5:00

2:30

320

5:00

BL 08/07/02

(8X)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

10/07/02 (8)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

10/07/02 (8)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



08/07/03 ff

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-08-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39914
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-2
Inspection Dwg: D2939 Rev: C DSK: Rev:		Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article  Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.114	0.116	0.116	0.116	0.115
B	0.100	0.140		.116	0.112	0.114	0.114	0.114
C	0.100	0.140	0.115	0.114	0.1165	0.118	0.118	
D	0.210	0.230		.220	.220	0.221	0.221	0.221
E	1.245	1.255		1.2449	1.2495	1.2495	1.250	1.249
F	1.245	1.255		1.251	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.501	2.501	2.500
H	0.510	0.515		0.511	0.511	0.511	0.511	0.511
I	1.572	1.582		1.577	1.577	1.576	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.258	.258	0.259	0.259	0.259
L	0.312	0.317		0.316	0.316	0.316	0.316	0.316
M	0.235	0.240		0.240	0.240	0.239	0.238	0.238
N	0.100	0.140		.121	.121	0.121	0.121	0.121
O	0.540	0.560		.550	0.5525	0.554	0.554	0.554
P	0.490	0.510		0.490	0.500	0.500	0.499	0.499
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720
R	2.720	2.760		2.750	2.750	2.750	2.749	2.750
S	0.240	0.270		.250	0.247	0.247	0.248	0.248
T	0.100	0.180		.131	0.135	0.135	0.135	0.135
U	1.625	1.635		1.630	1.630	1.630	1.629	1.630
V	1.362	1.372		1.370	1.370	1.368	1.367	1.368
W	0.316	0.321		.321	.321	0.321	0.321	0.321
X	1.250	1.270		1.260	1.260	1.260	1.260	1.260
Y	1.565	1.585		1.575	1.577	1.577	1.576	1.577
Z	0.178	0.198		.181	.181	0.188	0.188	0.188
AA								
AB								
AC								
AD								

#### Accept/Reject

Measured by: 8408/06/09 / DJP 08/07/01

Date: 08/07/01

Audited by: CML

Date: 08/07/02

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	DA

DART AEROSPACE LTD	Work Order:	39914
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-2
Inspection Dwg: D2939 Rev: C DSK: Rev:		Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article  Prototype

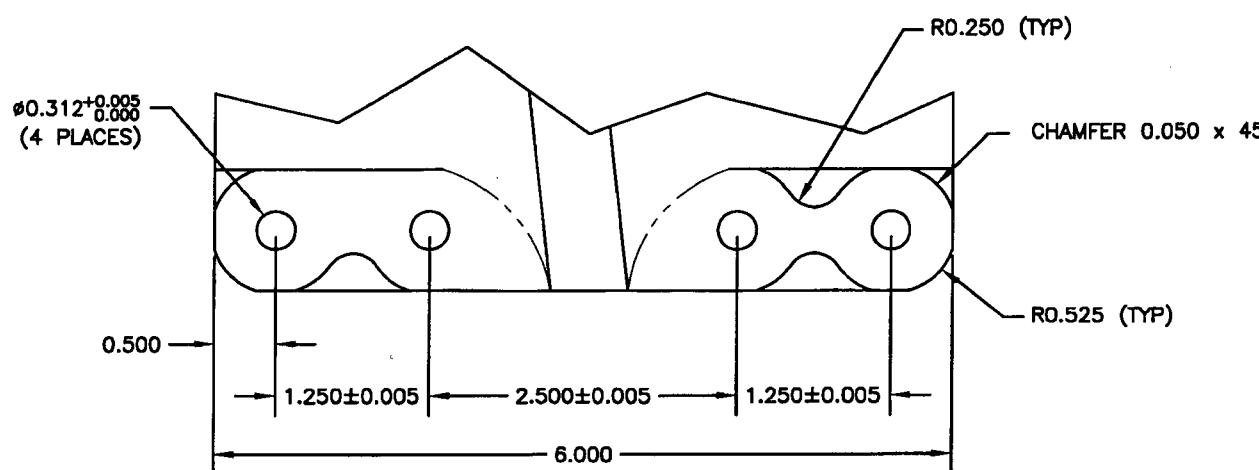
				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	4	5
A	0.100	0.140		0.117	0.115	0.116		
B	0.100	0.140		0.114	0.114	0.114		
C	0.100	0.140		0.118	0.116	0.116		
D	0.210	0.230		0.221	0.221	0.221		
E	1.245	1.255		1.249	1.249	1.250		
F	1.245	1.255		1.250	1.251	1.250		
G	2.495	2.505		2.500	2.500	2.500		
H	0.510	0.515		0.511	0.511	0.511		
I	1.572	1.582		1.577	1.578	1.578		
J	2.495	2.505		2.500	2.500	2.500		
K	0.257	0.262		0.259	0.259	0.259		
L	0.312	0.317		0.310	0.310	0.310		
M	0.235	0.240		0.238	0.238	0.238		
N	0.100	0.140		0.121	0.121	0.121		
O	0.540	0.560		0.554	0.555	0.555		
P	0.490	0.510		0.501	0.500	0.500		
Q	3.715	3.725		3.720	3.720	3.720		
R	2.720	2.760		2.747	2.748	2.748		
S	0.240	0.270		0.248	0.248	0.248		
T	0.100	0.180		0.135	0.135	0.135		
U	1.625	1.635		1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367		
W	0.316	0.321	Ø	0.321	0.321	0.321		
X	1.250	1.270		1.2605	1.2605	1.2605		
Y	1.565	1.585		1.577	1.577	1.577		
Z	0.178	0.198	Ø188	0.188	0.188	0.188		
AA								
AB								
AC								
AD								

#### Accept/Reject

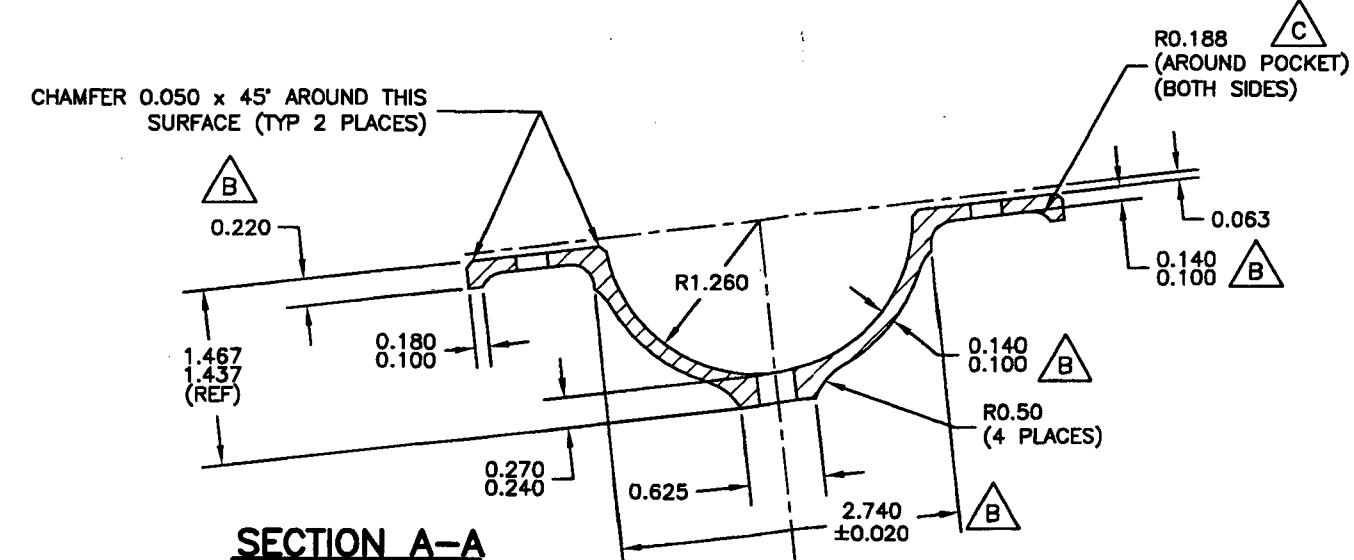
Measured by:	<i>DTJ</i>	Date:	<i>08/07/01</i>
Audited by:	<i>TMK</i>	Date:	<i>08/07/02</i>

Prototype Approval:	N/A	Date:	N/A
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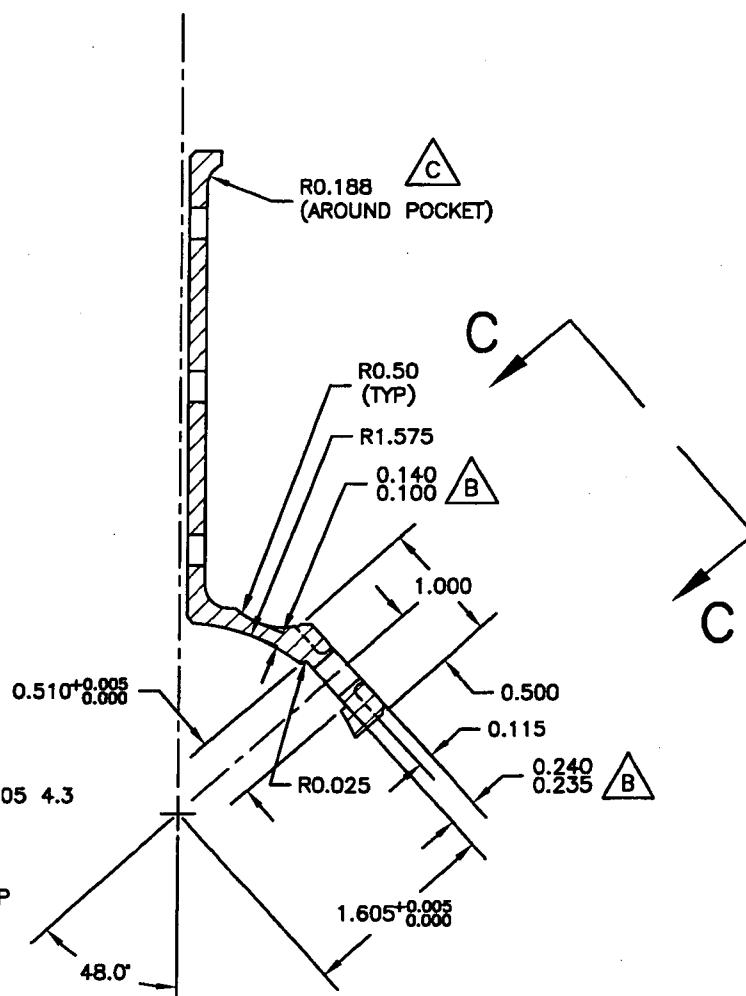
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD <i>JK</i> <i>DA</i>	



VIEW C-C



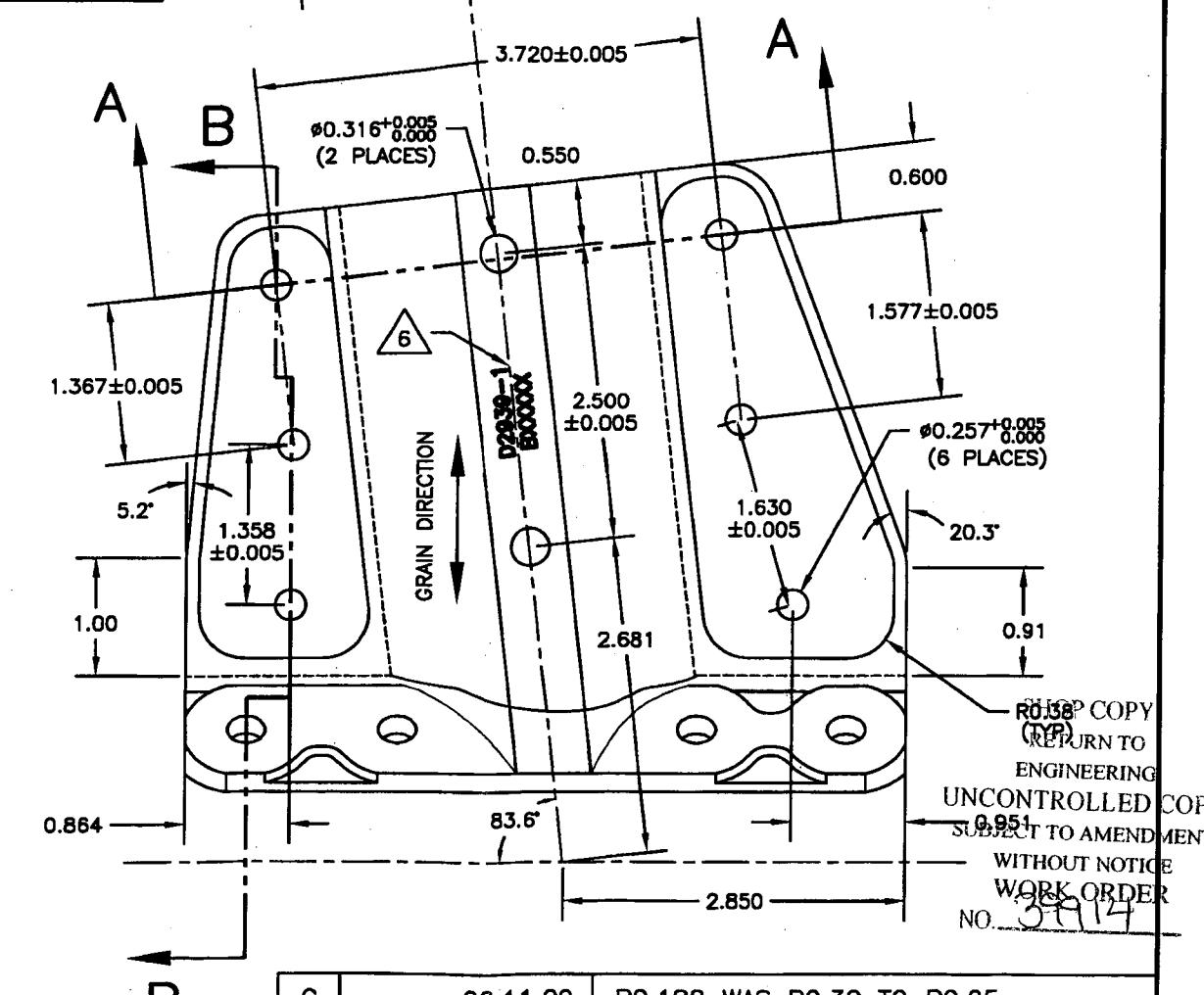
SECTION A-A



SECTION B-B

D2939-1 LH SADDLE (SHOWN)  
D2939-2 RH SADDLE (OPPOSITE)

- NOTES:**
- MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
  - FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
  - BREAK ALL SHARP EDGES 0.010 TO 0.020
  - TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - ALL DIMENSIONS ARE INCHES
  - ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE

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DART AEROSPACE USA, INC.

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. BELLEVUE, WA
P	CB	
CHECKED	APPROVED	DRAWING NO. D2939
DATE		TITLE SADDLE INSIDE
06.11.09		SCALE 2:3

07.02.12